

Work Order ID 57820

April 16, 2010 10:41:45 AM



Page 1

Item ID: D3909-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Stud

Start Date: 16/04/2010 Start Qty: 6.00



Required Date: 29/04/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Ref 10.04.16

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

0.00



Doosan

Memo

0.00

2L 10/04/17

(6)

Doosan Lathe

turn as per dwg and folio FA872

DWG REV: B

FOLIO REV: N/A

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

2L 10/04/17

6 0



QC

Memo

0.00

Quality Control

Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

- | | |
|--|--|
| 1. <i>Overproduction</i> | 2. <i>Rework</i> |
| 3. <i>Transportation</i> | 4. <i>Inappropriate / over Processing</i> |
| 5. <i>Unnecessary Inventory</i> | 6. <i>Delays / Waiting</i> |
| 7. <i>Unnecessary Motions</i> | |

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTA 10/04/17

6 0

150

Identify as per dwg & Stock Location: *095 AAAA* 0.00



Packaging

Memo

0.00

Packaging

10/04/2010

160

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/04/2010
MF
10-4-20



Lean Training Event

Picklist Print

April 16, 2010 10:41:44 AM

Page 1

Work Order ID: 57820

Parent Item: D3909-5

Parent Item Name: Eyebolt Stud

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	45.2000	1.5789			



303 Round Bar 1.00

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT028

113325

45.2

45.2

1.6

SL 10/04/17

603
630

DART AEROSPACE LTD		Work Order: 57820
Description: eyebolt stud		Part Number: D3909-5
Inspection Dwg: D3909	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.129	+0.005 -0.001	.129	✓			
1.38	+0.030 -0	1.385	✓			
.400	+0 -0.010	.396	✓			
.700	+0.010 -0	.702	✓			
5.030	+0.010 -0.010	.030	✓			
.375	+0 -0.020	.368	✓			
.700	+0 -0.010	.700	✓			
.250	+0.010	.250	✓			
1.30	+0.030	1.299	✓			
5.06	+0.030	.060	✓			
2.68	+0.030	2.682	✓			
.310	+0.010	.311	✓			
.750	+0 -0.010	.750	✓			
.375(pitch)	+0.010	.375	✓			
1.00	+0.030	1.00	✓			
.75	+0.030	.750	✓			
.735	+0.010 -0	.740	✓			

Measured by: SL	Audited by: DJP	Prototype Approval:	N/A
Date: 10/04/17	Date: 10/04/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

C

B

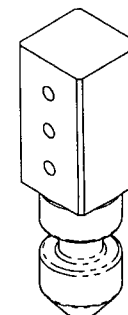
A

D

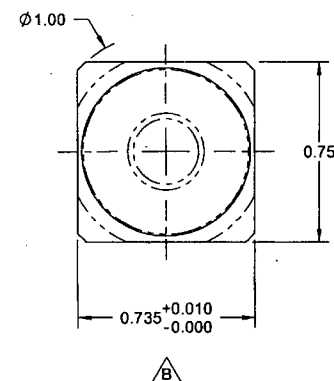
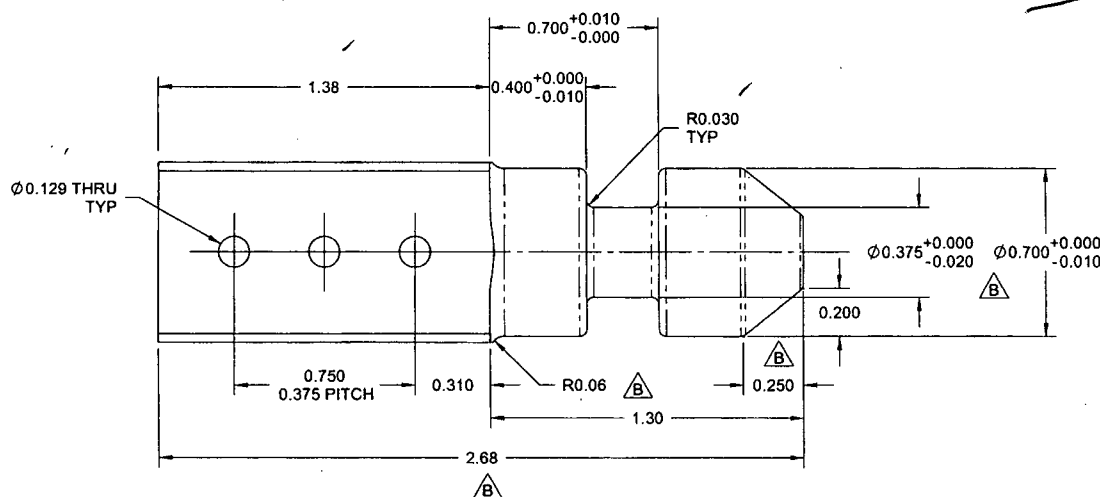
C

B

A



w/o 57820



D3909-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-04-07

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.04.06	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1